



Dart Aerospace Ltd.
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D5639-2**Job Sheet 197940****Part No:** D5639-2**Job Qty:** 6 pcs**Part Name:** Saddle, Inboard, RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/18/19**Job Tracking No:****Due Date:** 8/2/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D5639 REV.A IPP REV.A NEW ISSUE 19/02/06 JFS VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	6 pcs	8/2/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/08/28
							HAAS - 4		
110	HAAS 4 Axis - B4B	6 pcs	8/2/19		3.00	6.67	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/08/31
							HAAS - 4 - B4B		
120	QC 2	6 pcs	8/2/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S209645**Part:** D5639-2**Job No:** 197940**Serial No/Batch:** S209645**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/28/19

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130 QC 8	6 pcs	8/2/19	0.00 0.00	QC 2 - 57	19/08/31
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	8/2/19	0.00 0.75	QC 8 - 39	from 19/09/03
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
150 QC 7	6	8/2/19	0.00 0.00	Handfinish - 1 - 5 - B4B	SEP 03 2019
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	

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	pcs				QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	SEP 10 2019
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
152 Spray Paint - 2 - B4B	6 pcs	8/2/19	0.00 3.00		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
154 QC 14	6 pcs	8/2/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	SEP 12 2019
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
160 Packaging 3-1 - Stock - B4B	6 pcs	8/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	

DAS
SEP 10 2019
9:58

RD 19-9-10

DAS
SEP 12 2019
40
9:59

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
170 QC 21 - SA	6 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21	9-89
				QC 21 - SA - 70	
				QC 21 - SA - 53	SEP 1 11 11 AM

Part Op 110 - 1-Machine per folio FC513 DWG REV: A FOLIO REV: A 2- Deburr and break all sharp edges

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

152 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5200299 PAINT GLOSS BLACK

PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5155831

154 - (QC14- Inspect Spray Paint)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	6 pcs (1 ea)	100-Machining - Issue SN	S184 644

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	D6101-001	6	33	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order: 197980
Description: Saddle Inboard		Part Number: D56392
Inspection Dwg: D5639	Rev: A DSK: ☒ Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions					
				1	2	3	4	5	6
A	110	130		120	121	120	119	120	118
B	2035	0410		375	375	375	375	375	375
C	110	130		118	120	120	119	120	116
D	256	263		257	257	257	257	257	257
E	1870	1880		1875	1875	1875	1875	1875	1875
F	1870	1880		1875	1875	1875	1875	1875	1875
G	635	645		640	640	639	639	639	639
H	1395	1405		1400	1400	1400	1400	1400	1400
I	1395	1405		1400	1400	1400	1400	1400	1400
J	1943	1952		1950	1948	1950	1950	1952	1950
K	2308	2338		2333	2331	2330	2330	2333	2330
L	241	261		250	250	251	251	251	251
M	1565	1585		1575	1575	1575	1575	1575	1575
N	22x45	28x45		055x45	057	053	056	053	053
O	213	223		208	206	206	206	206	206
P	113	133		128	126	126	126	126	126
Q	216	222		175	175	175	175	175	175
R	110	130		122	125	122	123	124	123
S	675	695		665	685	683	685	685	685
T	1346	1360		1349	1357	1357	1357	1357	1357
U	1125	1145		1135	1135	1135	1135	1135	1135
V	5990	6010		6000	6000	6000	6000	6000	6000
W	107	113		1105	1102	1105	1103	1105	1105
X	490	510		500	500	499	500	500	500
Y	490	510		500	499	500	501	501	500
Z	1245	1255		1250	1250	1250	1250	1250	1250
AA	2495	2505		2500	2500	2500	2500	2500	2500
AB	1245	1255		1250	1250	1250	1250	1250	1250
AC	312	319		313	313	313	313	313	313
AD	22	28		250	250	250	250	250	250
AE	110	130		120	118	120	119	121	120
AF	115	135		125	125	125	125	125	125
AG	510	515		513	513	513	513	513	513
AH	235	240		238	237	237	237	237	237

Accept/Reject

Measured by: SBL	Date: 19/06/31
Audited by: JML	Date: 19/09/09
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD				Work Order:	197940
Description:				Part Number:	D56392
Inspection Dwg:	Rev:	DSK:	Rev:		

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FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A								
B								
C								
D								
E								
F								
G								
H								
I								
J								
K								
L								
M								
N								
O								
P								
Q								
R								
S								
T								
U								
V								
W								
X								
Y								
Z								
AA								
AB								
AC								
AD								
AE								
AF								
AG								
AH								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
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Route update only

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